

Date: Thursday, 24/07/2008 8:20:48 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FWD ADJUSTABLE BLADE SUPPORT ASSY		
Job Number	: 40606-1			Part Number	: PB674300111		
Estimate Number	: 13435			Drawing Number	: B6743001 P.8		
P.O. Number	:			Project Number	: N/A		
This Issue	: 24/07/2008 S.O. No. :			Drawing Revision	: B1		
Prsht Rev.	: NC			Material	:		
First Issue	: 17/07/2008 Type : LARGE FAB ASSY			Due Date	: 24/07/2008		
Previous Run	:			Qty:	5		
Written By	:			Um:	Each		
Checked & Approved By	: MF 08-07-24						
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	PB6743001247	Inner Tube	 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Inner Tube batch: 340689	
2.0	PB6743001249	Inner Tube Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Inner Tube Bushing batch: 10537	
3.0	PB6743001253	Gusset	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Gusset batch: 340045	
4.0	PB6743001254	Gusset	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Gusset batch: 340053	
5.0	PB674300167	PB67-43001-67	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		PB67-43001-67 batch: 340243	



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Part Number: 40606

Part Number: PB674300111

Number:



Seq. #:	Machine Or Operation:	Description :
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		 Comment: LARGE FABRICATION RESOURCE 1 1- make a 0.090" chamfer in the 1.00" hole before welding 2- assemble parts and weld as per dwg <i>8/08-07-22</i>
7.0	QC9	VISUAL WELDING INSPECTION
		 Comment: VISUAL WELDING INSPECTION <i>8/08-07-29(5)</i>
8.0	QC5	INSPECT WORK TO CURRENT STEP
		 Comment: INSPECT WORK TO CURRENT STEP <i>8/08/08/26(8) 8/08-07-29(5)</i>
9.0	MS124780	HELICAL INSERT
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) HELICAL INSERT <i>17935 8/08-07-29</i>
10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- grind weld flush in area of PB67-43001-249 only 2- tap drill for helical 3- install helical insert as per dwg <i>8/08-07-29(5)</i>
11.0	QC5	INSPECT WORK TO CURRENT STEP
		 Comment: INSPECT WORK TO CURRENT STEP <i>8/08-07-29(5)</i>
12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>N/A</i>
13.0	POWDER COATING	POWDER COATING
		 Comment: POWDER COATING M 102316 1- MASK TUBE FROM BASE TO GUSSET 2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3 <i>8/08-07-31 5. M. 102316 8/08-07-31</i>



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Job Number: 40606

Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

2:30

OVEN TEMPERATURE:

320°

FINISH TIME:

3:00

(5x)

m-f

08/07/31

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL



08/07/31

(5)

15.0 PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

90 Degree Cover Plate

batch: 400269

was  
done for  
Jones,  
Spirix



08.08.26

16.0 PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-83

batch: 40096



08.08.26

17.0 MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

batch: 18834



08.08.26

18.0 NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

WASHER

batch: 106772 108700



08.08.26

19.0 SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



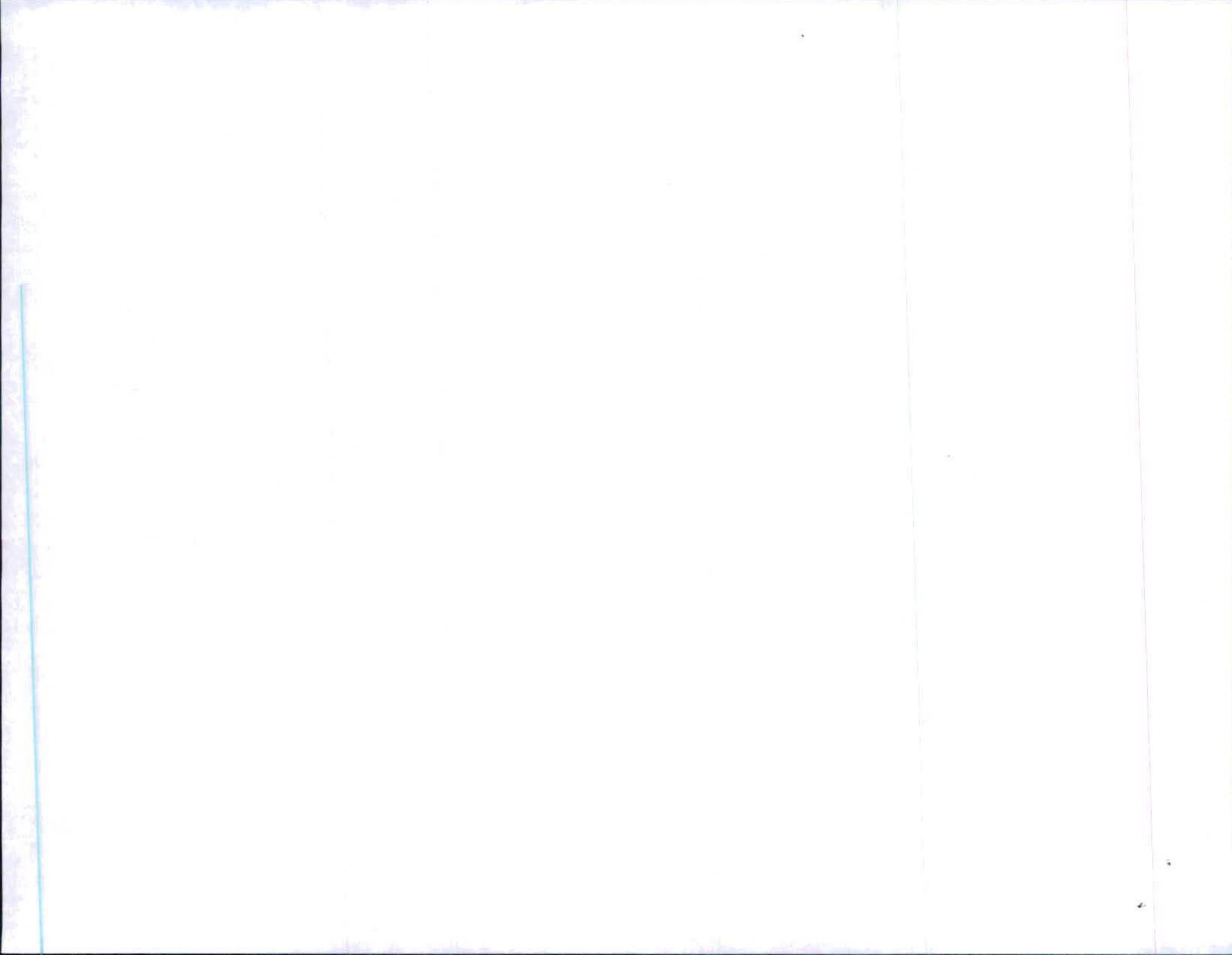
Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg



08.08.26



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20.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S08/07/23 (2)

21.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: cart in bldg

S08/07/23 (2)

22.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08/10/23

